Knee Femoral

A26-300

Based on a given 3D-model the grinding pathes can be generated along predefinable textures (spirals, oblique lines, ..) on the surface. Within our softwarepackage Meshintersector the number of slices, moveout and movein pathes can be adapted to the various forms of edges. Each part of the 3D surface to be executed is attached to an operation.

1. Cycletime for Production

Tool specifications LxHxB 65x60x70 Material Medical Steels		
Operations	Pregr.Surface	Fin. Surface
Feed [mm/Min]	400	2000
Power [kW]	1	1
Cutting feed [m/s]	26	33
Used wheels	36	37
Grinding time [s]	1815	851
Total cycle time		44 Min 25

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.
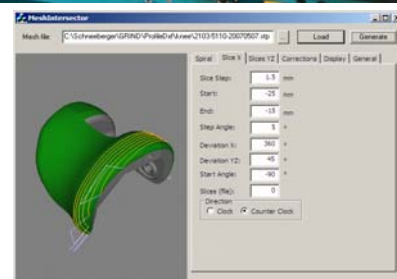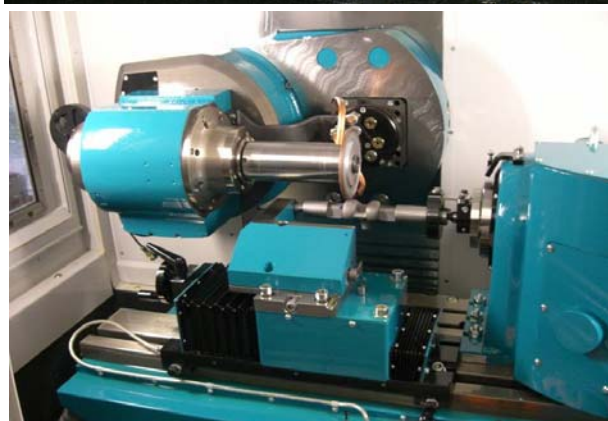
2. Used Grinding Wheels

36 Ø125 14F1 B126
37 Ø125 14F1 B54
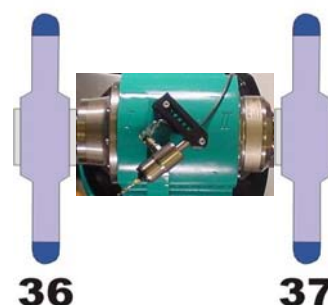
3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, NORMA CFG, Special Clampings
Control: Fanuc 160i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 4.3, DXQ

responsible engineer: OP,10.1.08

www.schneeberger.ch

TECHNOLOGY FOR TOOLING

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